

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67915

Monday, April 04, 2011 2:55:55 PM



Page 2

Item ID: D3280-3L02

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, RH

Start Date: 4/4/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3280 and Folio FTA 012

Dwg. Rev. EFolio Rev. R

x4

OK
11/04/12

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

x4

OK
11/04/12

130

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

x4

OK
11/04/12

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Dart Aerospace Ltd

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NOTE: Date & initial all entries

Work Order ID 67915

Monday, April 04, 2011 2:55:56 PM



Page 4

Item ID: D3280-3L02

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, RH

Start Date: 4/4/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/25 J

UMF
11-04-25

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, April 04, 2011 2:56:02 PM

Page 1

Work Order ID: 67915



Parent Item: D3280-3L02



Parent Item Name: Floor Protector, RH

Start Date: 4/4/2011

Required Date: 4/6/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev. C Added colour code to D3280-3 11/03/03 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-02		Purchased	No			100	sf	808.4400	4.333	18.24421			
GE PLASTICS LEXAN SHEET													

Location

therm

Loc Qty

808.44

Loc Code

106751

105.89

110877

702.55

18.24421 sf 61

DL
11/04/09

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	67815
Description: R22 Floor Protector, RH		Part Number:	D3280-3
Inspection Dwg: D3280	Rev: <i>DL</i> <i>08/11/04/19</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	<i>✓</i>			
Shape Definition	<i>✓</i>			
Texture Retention	<i>✓</i>			
Material imperfections such as bumps, cracks, voids, scratching	<i>✓</i>			

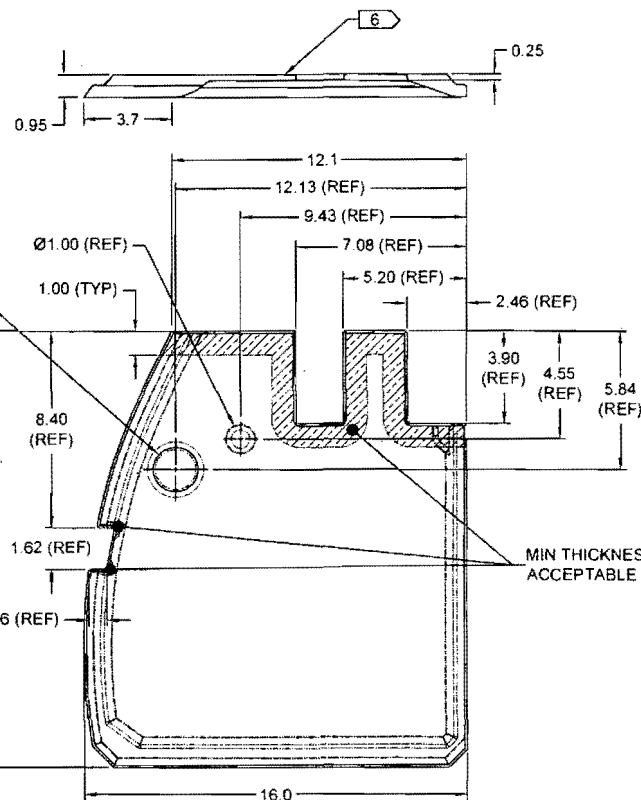
Measured by: <i>DL</i>	Date: <i>11/04/12</i>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.3	+/-0.100	<i>18.25"</i>	<i>✓</i>		<i>TAPE DL-01</i>	
15.8	+/-0.100	<i>15.75"</i>	<i>✓</i>		<i>TAPE DL-01</i>	
12.1	+/-0.100	<i>12.125"</i>	<i>✓</i>		<i>TAPE DL-01</i>	
0.95	+/-0.030	<i>0.892"</i>	<i>✓</i>		<i>VERK DL-02</i>	
0.25	+/-0.030	<i>0.028"</i>	<i>✓</i>		<i>VERK DL-02</i>	
0.070	Min	<i>0.075"</i>	<i>✓</i>		<i>CALIP DH-DT</i>	
0.050	Min	<i>0.064"</i>	<i>✓</i>		<i>VERK DL-02</i>	

Measured by: <i>DL</i>	Date: <i>11/04/12</i>
Audited by: <i>BB</i>	Date: <i>11/04/20</i>
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL <i>JA</i>	<i>DL</i>



D3280-1 FLOOR PROTECTOR

D3280-1 NOTES:

- 1) MATERIAL: -1L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
-1L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-1Lxx" AND B/N PER QSI 044 6.4
- 7) WEIGHT: D3280-1L02 = 0.94 lb D3280-1L08 = 1.13 lb
- 8) THERMOFORM WITH MOLD D3280-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED



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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67915

RELEASED
2011-03-02
MD

E	REVISE NOTES (ZN A8-1, A8-2)	RF	11.03.01
D	THICKNESS 0.093 WAS 0.125, MIN. THICKNESS 0.070 WAS 0.080, P/N & B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2); CORRECT WEIGHTS (ZN A8-1, A8-2); HOLE SIZE Ø1.88 WAS Ø0.211 (ZN C7-1)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.12
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3280 TITLE FLOOR PROTECTOR <small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	RF		
CHECKED	<i>JP</i>		
MFG. APPR.	<i>JP</i>		
APPROVED	<i>JP</i>		
DE APPR.	<i>JP</i>		
DATE	11.03.01	REV. E SHEET 1 OF 2 SCALE NTS	

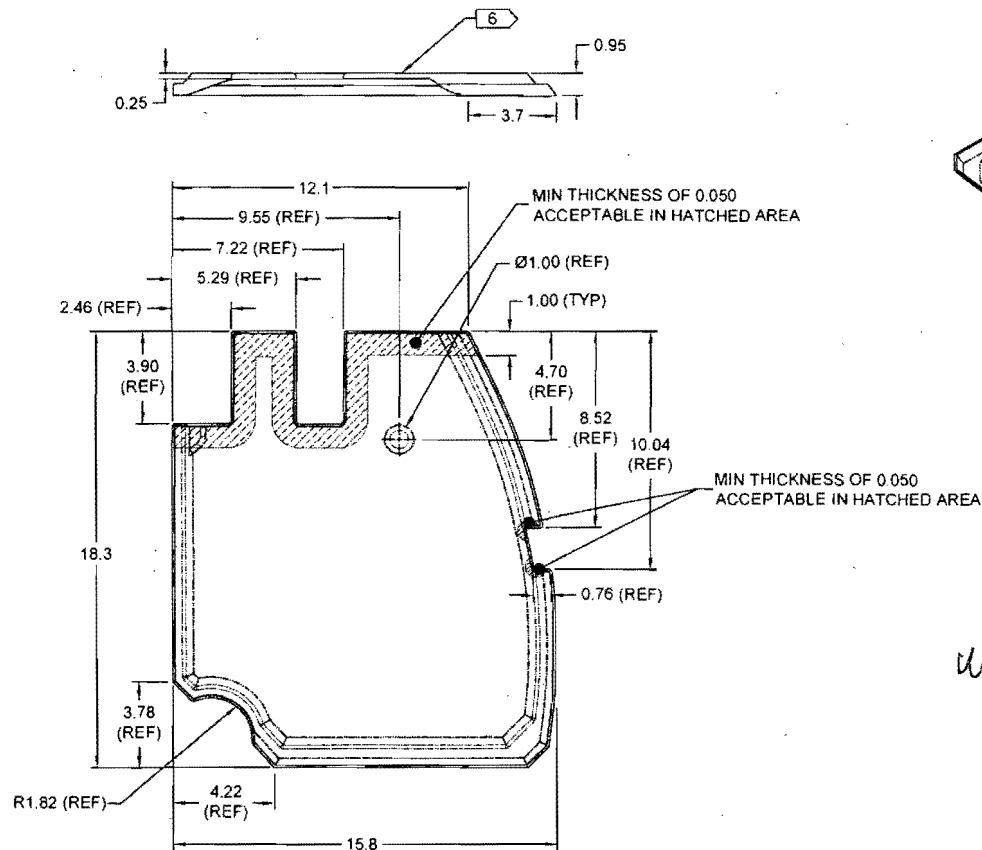
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D3280-3 FLOOR PROTECTOR

D3280-3 NOTES:

- 1) MATERIAL: -3L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
-3L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-3Lxx" AND B/N PER QSI 044 6.4
- 7) WEIGHT: D3280-3L02 = 0.88 lb D3280-3L08 = 1.03 lb
- 8) THERMOFORM WITH MOLD D3280-3T1 PER DART QSI 022: TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED



RELEASED
2011-03-02

DESIGN	90	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D3280	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FLOOR PROTECTOR	NTS
DATE	11.03.01	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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